Memo

Quality Control

DQA:			Date:														
			_			WORK ORDER NON-	-CC	ONFO	RMANCE / UI			.,		_	AEROSPACE		
QA Closed:			Date:			· · · · · · · · · · · · · · · · · · ·				10	Nork (rder u	odate only				
Work Orde	r:					DISPOSITION				AGAINST D	DEPAR	TMENT	/PROCESS		:		
Work Orac						Rework	1		Skid-tube	Crosstube			Water Jet	Γ	Engineering		
Part N	lo.					Scrap			Machining	Small Fab	┥	Pro	d. Eng. Coor.	⊢	Quality		
	•					Use-as-is	1		noforming	Finishing	_ F		re/Packaging	-	Other		
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	-			
Root	-1				Desci	ription of work order update		nitial	Act	ion	Tsi	gn &					
Cause		Date	Step	Qty	Desci	or non-conformance	1	ief Eng		iption		on ∝ Date	Verificatio	n	QC Inspector		
Design			0.00	~~7			-			<u> </u>							
Doc/Data		•					1										
Equip/Tooling									<u> </u>								
Handling/Pre															:		
Material																	
Operator																	
Offset/Setup											ŀ						
Process				İ									:		1		
Supplier									į				:				
Training		,															
Transport						•					1						
Unapproved						· ·								٠			
				•••	,		FA	ULT CA	TEGORY								
Landi	ng (Sear				General	_	-		_				_	_		
,		Bending				Bend		Folio/F	Program		Out	side Dim	ensions		Pressure/Forced		
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	$ldsymbol{le}}}}}}$	Grain			Ove	r/Under	tolerance	_	Set-up		
		Cracks				Broken/Damage/Defect	L	Hardwa		1		Incorre		_	Temperature/Cure		
		Crimp/Kin	k/Ripple	/Wave	igspace	Burrs		1 .	ion Incomplete/Ur	·		Lost/M	_		Weld		
	_	Cuffs			igspace	Contamination		4	tions Incomplete/U	Jnclear	\neg	Moved			Wrong Stock Pulled		
		Crushing				Countersink	<u></u>	1	gned/off center	L		tioned \	_		7		
		Heat Trea				Cut Too Short	_	Mislabe		Ĺ	Pov	er Loss/	'Surge		Other		
	L	Inspection	-	Tube		Drawing	Misread										
	L	Marks/Ch				Drill Holes			Off-set								
		Turning S				Finish	——		Out of Calibration								
		Wave/Tw	ist in Tub	e		Fit/Function		Out of Sequence									

Work Orde		0715		*11(7715	*							Page 2
Item ID: Revision ID: Item Name:	D3413-1 O-Ring			Accept	*N9	nn	140	100)*	-	Start Stop		S1* S2*
Start Date: Required Date: Reference:	1/07/14 1/07/14	Start Qty: 16.00 Req'd Qty: 16.00	*16 *16		i i	Item ID):						
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):		Dat			F		Start Stop		R1* R2*
Sequence ID/ Work Center II 120 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	To AS 27 9-59	ol ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
150 *1 50* Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) Memo START TIM	97 //:5:	0.00 OVEN TEMPERATUR	 	i			16	6	_/4	1-4-/	<u> </u>

0.00

160

160

Quality Control

QC3- Inspect Part Finish

Memo

DQA:			Date:												
			<u>.</u>			WORK ORDER NON-	-CC	ONFO	RMANCE / UP						AEROSPACE
QA Closed:			Date:						_	V	Vork Ord	der up	odate only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTN	/IENT	/PROCESS		
	•					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•				_	Use-as-is		Thern	noforming	Finishing	Red	c/Sto	re/Packaging		Other
NCR N	lo.		·			Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	\Box	I Initial	Actio	on	Sign	. &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Da	te	Verificatio	n	QC Inspector
Design															
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Offset/Setup															
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Training							l								
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Unapproved			İ		<u>. </u>		<u> </u>						<u> </u>		
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Landii	ng (1				General]		Г	المراجعة المراجعة				lo
		Bending	- .		\vdash	Bend BOM/Boute		-1	Program	-	→		ensions	-	Pressure/Forced
		Centre No	ot Concer	ntric	⊢	BOM/Route Broken/Damage/Defect	⊩	Grain		-			tolerance	\vdash	Set-up
		Cracks Crimp/Kir	ak/Binnlo	Maya	\vdash	Burrs	<u> </u>	Hardwa	are ion Incomplete/Und	L	Part In				Temperature/Cure Weld
	-	Cuffs	ik) vibbie	y wave		1	-	1	•	· –	Part M		-		
		Crushing			\vdash	Contamination Countersink	\vdash	4	tions Incomplete/Ui gned/off center	licical	Position				Wrong Stock Pulled
į	\vdash	Heat Trea			-	Cut Too Short	\vdash	Mislabe		 	Power		_		Other
	-	Inspection		Tube	-	Drawing		Misrea		L		LU33/	BC	L	100.101
	一	Marks/Ch				Drill Holes	\vdash	Off-set							
	\vdash	Turning S				Finish	\vdash	-{	Calibration						
		Wave/Tw				Fit/Function		4	Sequence						

Work Order ID 110715

January-07-14 3:01:26 PM

Required Date: 1/07/14

110715

Page 3

Item ID:

D3413-1

Accept

N900040100

Date:

Setup Start

Revision ID:

Start Date:

Item Name:

O-Ring 1/07/14

Start Qty: 16.00

Req'd Qty: 16.00

16 *16*

Date:____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Start

Stop

Stop

Sequence ID/ **Work Center ID**

Operation **Description**

QC:

Set Up/ **Run Hours** Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

170

Identify as per dwg & Stock Location: 37464

0.00

APR 1 0 2014

170 Packaging

Packaging

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00

120

QC

Memo

0.00

14-4-14 404-11

Quality Control

DQA:		Date:	-										
					WORK ORDER NON-	-CC	ONFO	RMANCE / UI	PDATE				AEROSPACE
QA Closed:		Date:								W	ork Order up	odate only	
Mark Ordan					DISPOSITION				AGAINST	ÐΕ	PARTMENT	/PROCESS	
Work Order:					Rework	1		Skid-tube	Crosstube		1	Water Jet	Engineering
Part No					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
1 47 6 140	•			 .	Use-as-is			noforming	Finishing		4	re/Packaging	Other
NCR No					Suspected Unapproved	1		Large Fab	Composite		i '	Supplier	† H
						,			·				
Root				Desc	ription of work order update	П	nitial	Act	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
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Doc/Data	_	İ											
Equip/Tooling	_												
Handling/Pre	_												
Material	_					i							
Operator	_												
Offset/Setup													<u> </u>
Process	4												
Supplier	_		1			1							
Training	4												
Transport	-	Ì											
Unapproved			1	l			III T CA	TECORY			<u> </u>	<u> </u>	
l a malina					Canaval	FA	ULI CA	TEGORY	· · · · · · · · · · · · · · · · · · ·				
Landing	_	.~			General Bend		ادمانه/ا	Program		Г	Outside Dim	ensions [Pressure/Forced
 -	Bendi	ਾਂਡ • Not Conce	ntric	\vdash	BOM/Route	-	Grain	riogram		-	Over/Under	—	Set-up
	Cracks		HUIC	H	Broken/Damage/Defect	\vdash	Hardwa	are		-	Part Incorre	 	Temperature/Cure
-	⊣	/ Kink/Ripple	a/Wava		Burrs	\vdash	-	ion Incomplete/U	ngualified	\vdash	Part Lost/M	_	Weld
 	Cuffs	, Kirik, Kippi	c, wave	\vdash	Contamination	\vdash	- 1 '	tions Incomplete/U	-	\vdash	Part Moved	-	Wrong Stock Pulled
 	Crush	ng		\vdash	Countersink	-	-	gned/off center	J., 010u1	\vdash	Positioned V	∟∟ Vrong	J
	Heat	_			Cut Too Short	\vdash	Mislab	-			Power Loss/		Other
	_	tion Strip ir	n Tube		Drawing		Misrea			_	_	~ L	
		/Chatter			Drill Holes		Off-set						
-	_	g Sequence	9		Finish		┥	Calibration				****	
	_	/Twist in Tu			Fit/Function		Out of	Sequence					· · · · · · · · · · · · · · · · · · ·

Picklist Print

January-07-14 3:01:25 PM

Work Order ID:

110715

Parent Item:

D3413-1

Parent Item Name:

O-Ring

Comments:

IPP Rev:A05.09.13New issueKJ/JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

Start Date: 1/07/14

Required Date: 1/07/14

Page 1

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty		Date Issued	Status
M304B0.250X4.000 304 BAR .250 x 4.00	·	Purchased	No			100	i f	11.5000	0.25	4.210526 4	5.0		Jm14-04-
304 BAR .230 X 4.00				Location		Loc Qty	; <u>L</u> a	oc Code					

11.5

11.5

FPC851

123313

MAT051

128247.

DQA:			Date:												
OA Classid			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		١٨/٥	ork Order up	odata anly		AEROSPACE
QA Closed:			Date:	···						<u> </u>	VVO	ork Order up	date only	Ш	
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
	•					Rework]		Skid-tube	Crosstube	\neg		Water Jet		Engineering
Part N	lo.					Scrap		i 1	Machining	Small Fab	╗	Pro	d. Eng. Coor.	П	Quality
	•					Use-as-is	1		noforming	Finishing			e/Packaging	П	Other
NCR I	١o٠					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		Initial	Act	ion		Sign &		\neg	
Cause		Date	Step	Qty	Desci	or non-conformance	i	ief Eng		iption		Date	Verification	n	QC Inspector
Design	П	Date	Осер	٩٠٠		or non-comornance		ner eng			_				До тороско
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Equip/Tooling															
Handling/Pre															
Material													i	ŀ	
Operator															
Offset/Setup											İ				
Process															
Supplier														ı	
Training							l							1	
Transport															
Unapproved			<u>.</u>				ł								
							FA	ULT CA	TEGORY						
Landi		i			_	General	_	1		,				_	1
		Bending				Bend	L	4	Program		\vdash	Outside Dim			Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain			-	Over/Under			Set-up
		Cracks				Broken/Damage/Defect	<u> </u>	Hardwa	•		Н	Part Incorred			Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	L	1 '	ion Incomplete/Ur		-	Part Lost/Mi	ssing		Weld
		Cuffs			_	Contamination	L	4	tions Incomplete/L	Jnclear	-	Part Moved		L	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink		-	gned/off center		-	Positioned V	_	_	1 .
	_	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabe				Power Loss/	Surge		Other
	_	Inspectio	•	Tube		Drawing		Misrea							
		Marks/Ch			<u> </u>	Drill Holes	<u></u>	Off-set							
	\vdash	Turning S	-			Finish	_	┥	Calibration						
1	1	Wave/Tw	vist in Tuk	oe .		Fit/Function	1	Out of	Sequence						

DART AEROSPACE LTD	Work Order:	110715
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	X	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/-0.030	3.884			U	Jhmos.
Ø2.00	+0.012/-0.001	2.006	_		V	
0.75	+/-0.030	0.753"			V	
Ø0.266	+0.006/-0.001	0.2684			V	
0.250	+/-0.010	0.254	_		V	
					77.4	
			DAS			

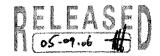
		27	 	
Measured by: Jm	Audited by:	9-89	Prototype Approval:	N/A
Date: 14-04-9	Date:	14/4/9	Date:	N/A

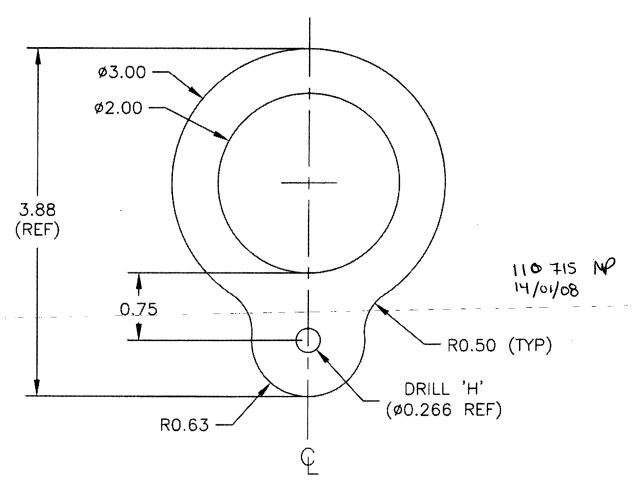
Rev	Date	Change	Revised by	Approved
Ā	07.09.06	New Issue	KJ/JLM	6



Tributa de la composição de la composição de la composição de la composição de la composição de la composição

DESIGN CP	DRAWN BY CP	DART	AEROSPACE USA, INC.
CHECKED M	APPROVED A	DRAWING NO.	REV. A
-Ht	##	D3413	SHEET 1 OF 1
DATE		TITLE	SCALE
05.03.16		RING	1:1
A	05.03.16	NEW ISSU	JE .





D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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